

Work Order ID 94785

94785

Page 1

December-20-12 8:53:17 AM

Item ID: D205-778-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Comfort Seat, LH/RH

Stop ***NS2***

Start Date: 12/19/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: 12-01-13 Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3800	B								
DSI 9508	A								
IIN D205-778	Rev B								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D205-778-011 CHG 003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

AS
15
9-89
132.11

1 Order mls 13-2-4

13/2/11 SPC

1K SP
130204

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 94785***94785***

Page 2

December-20-12 8:53:17 AM

Item ID: D205-778-011

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Comfort Seat, LH/RH

Start Date: 12/19/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				1			
120									
QC	Memo	0.00							
Quality Control									
130	Packaging	0.00				1			
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-778-101								
	Location: <u>6059</u>								
	PPP Rev: <u>5</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 13-02-12

NCR: Yes / No

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* - Picklist Print

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Page 1

Work Order ID: 94785

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
10.03-24 verified by:EC

IPP Rev:B as per DSI 9508 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD61 Washer		Purchased	No			110	Each	460.0000	16	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		460							
				5519		460							
BSP-42 Rivet		Purchased	No			110	Each	234.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST282		234							
				120930		34							
				121163		200							
D3752-1 Seat Frame		Manufactured	No			110	Each	2.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST252A		2							
				84031		2							
D3755-041 Seat Cushion		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST252A		4							
				84024		4							
D3756-041 Cushion		Manufactured	No			110	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST252A		5							
				81291		1							
				84025		4							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Page 2

Work Order ID: 94785

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 1.00

Required Qty: 1.00

D3758-041 Clamp	Manufactured	No		110	Each	28.0000	2	SP	SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST457	28					
			82181	28					
D3777-041 Clamp	Manufactured	No		110	Each	16.0000	2	SP	SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST457	16					
			73975	16					
D3800-3-200 Hook and Loop Strip (2" Hard)	Manufactured	No		110	f	93.9643	2	2.1052632	SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST065	93.9643					
			56393	33.9643					
			60044	60					
AN525-10R8 Screw	Purchased	No		110	Each	248.0000	8	SP	SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST344	48					
			120986	48					
			ST345	200					
			121165	200					
AN970-3 Washers	Purchased	No		110	Each	122.0000	8	SP	SP
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST342	122					
			121163	122					
AN960JD10 Washer	Purchased	No		110	Each	0.0000	8	SP	SP
			NAS1149D0363J						

December-20-12 8:53:17 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Page 3

Work Order ID: 94785

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

4,778.0000

8

Nut

8
SP13-02-04

SM3

Location

Loc Qty

Loc Code

FP001

143

122141

143

GA

458

122452

458

ST314

677

117885

32

119017

55

119075

138

123265

452

ST506

3500

123900

3500

Sk

December-20-12 8:53:17 AM

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Page 3

NCR: Yes / No

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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
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Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT-FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37
REF FAA STC: SR02704NY
REF EASA STC: EASA.IM.R.S.01518

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	DART AEROSPACE LTD	
DRAWN	<i>qp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIVET KIT	NTS
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